

Date: Monday, 4/23/2007 1:52:46 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 31996		
Estimate Number	: 12716		
P.O. Number	: <i>N/A</i>	Part Number	: D353635
This Issue	: 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3536 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 30755	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 4/30/2007
Checked & Approved By	: <i>07.01.25</i>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.6507 sf(s)/Unit Total : 13.0137 sf(s)

NEOPRENE SHEET 0.063

Batch: *M103104**SAD 07/05/03*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*SAD 07/05/03**(20)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/03**(20)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SC 07.05.03**20*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *1-11551116**PC 7/5/04 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/05/07

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31996

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

1907105/07

Job Completion



U 810507

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	31996
<b>Description:</b> Gasket		<b>Part Number:</b>	D3536-35
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	✓		Vern/MT	
19.75	+/-0.030	19.75	✓		M-T	
17.75	+/-0.030	17.75	✓		M-T	
14.25	+/-0.030	14.25	✓		M-T	
9.50	+/-0.030	9.48	✓		Vern	
4.75	+/-0.030	4.74	✓		Vern	
2.00	+/-0.030	2.00	✓		Vern	
6.00	+/-0.030	6.00	✓		Vern	
6.75	+/-0.030	6.75	✓		Vern/MT	
0.30	+/-0.030	0.30	✓		Vern	
0.30	+/-0.030	0.31	✓		Vern	
1.89	+/-0.030	1.89	✓		Vern	
Ø0.19	+0.005/-0.001	0.19	✓		Vern	
0.063	+/-0.010	0.063	✓		Vern	

<b>Measured by:</b>	JAD	<b>Audited by:</b>	SG	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/05/03	<b>Date:</b>	07-05-03	<b>Date:</b>	N/A

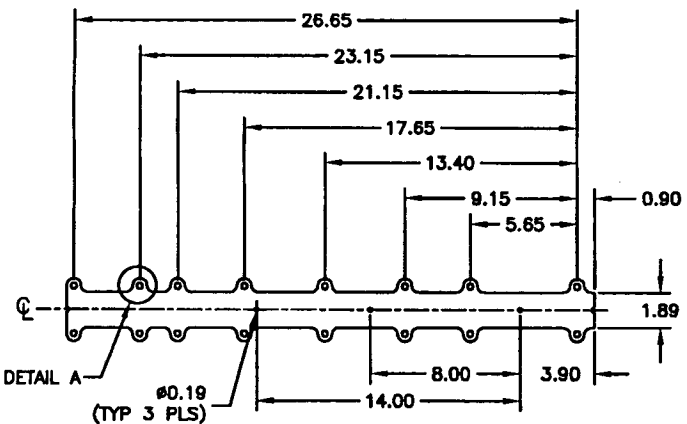
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

**DART**

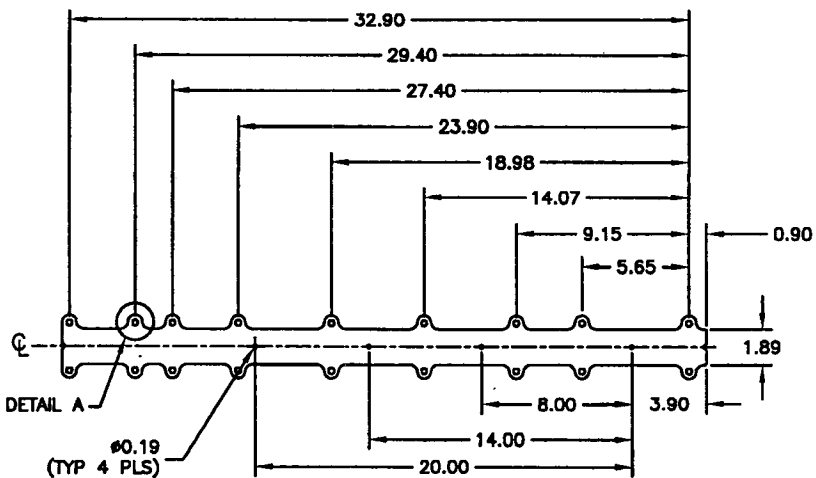
RELEASED

09-02-12-1

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
A	06.10.25	GASKET	NEW ISSUE	SHEET 1 OF 6
				SCALE 1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

**NOTES**

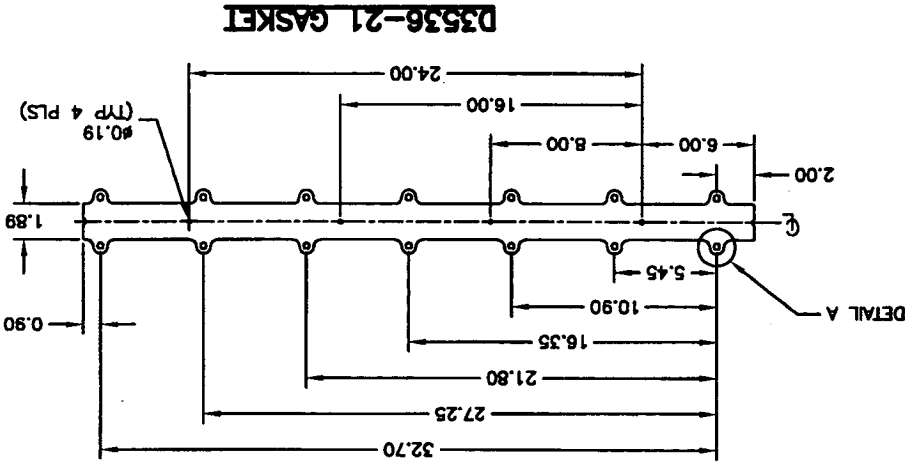
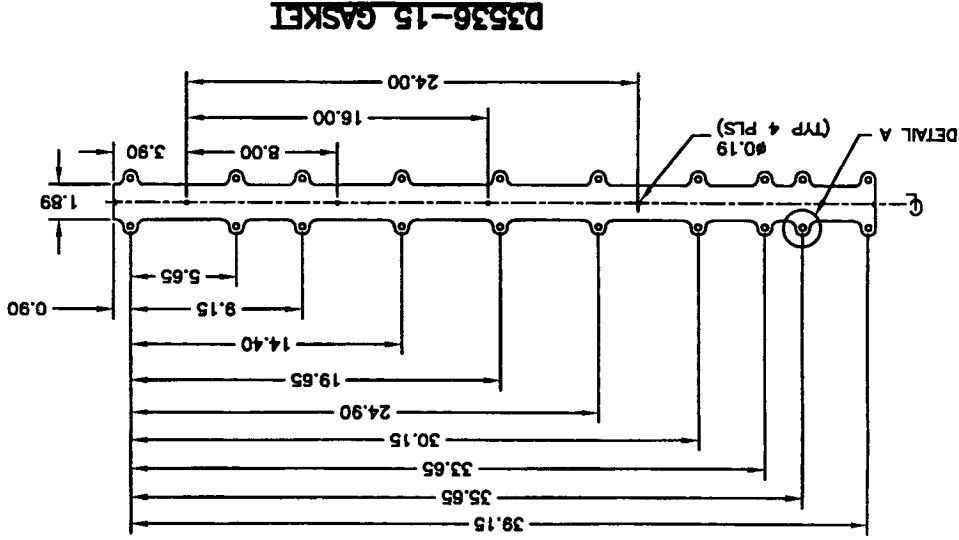
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WITHOUT NOTICE  
WORK ORDER  
NO. 319916



DESIGN <b>C.B</b>	DRAWN BY <b>C.B</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED 	DRAWING NO. <b>D3536</b>	REV. A SHEET 2 OF 6
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>		SCALE <b>1:10</b>

RELEASED  
07.02.12



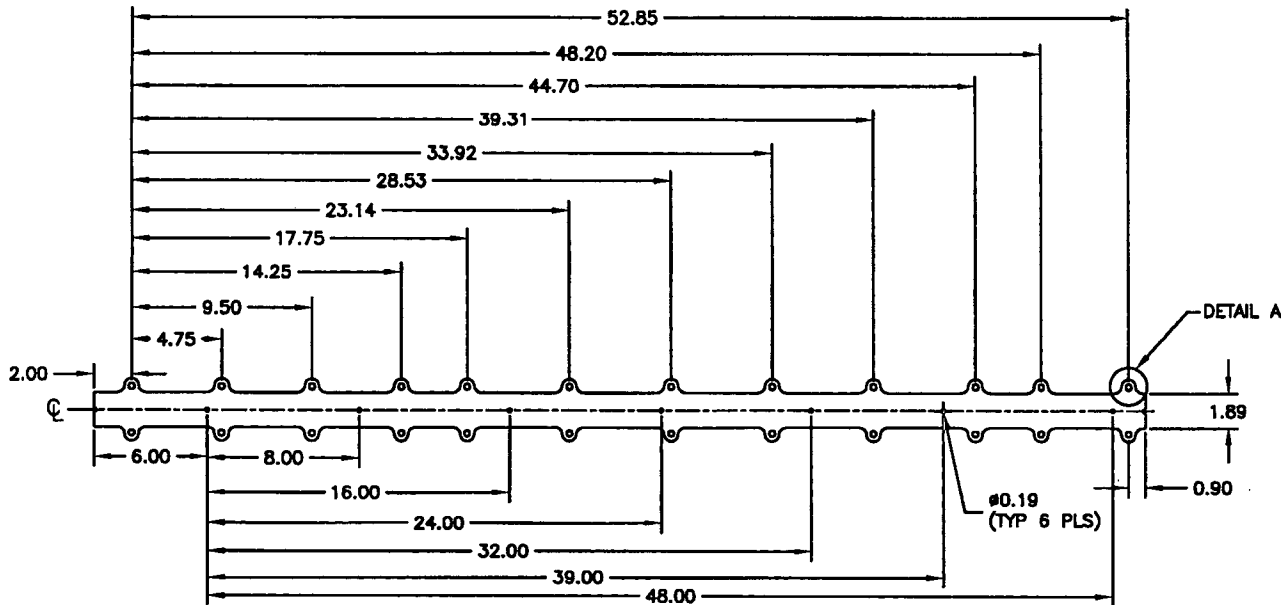
- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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NO. **31996**

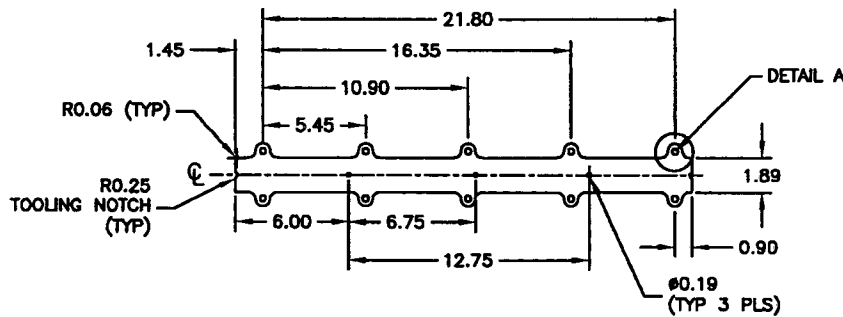
**DART**

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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07.02.12



**D3536-23 GASKET**



**D3536-25 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

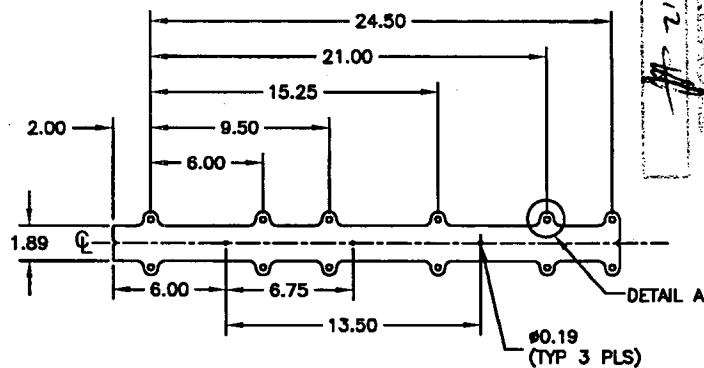
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WORK ORDER  
NO. 31994

# DART

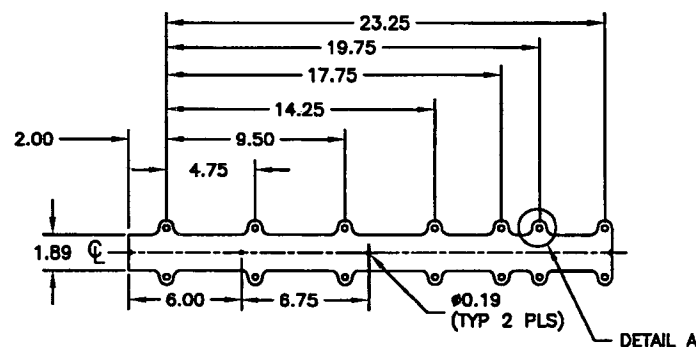
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 4 OF 6	SCALE <b>1:10</b>

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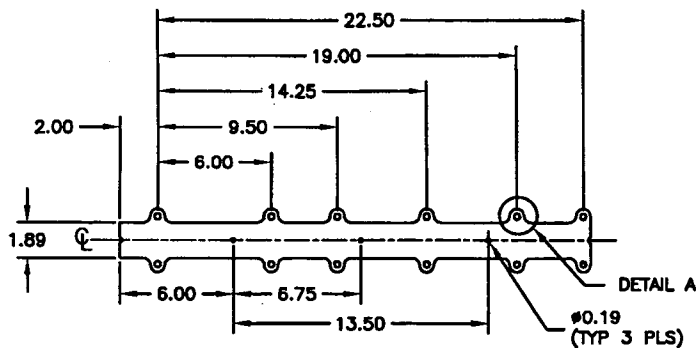
07.02.12



**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

SEE PAGE 6 FOR DETAILS AND SECTION

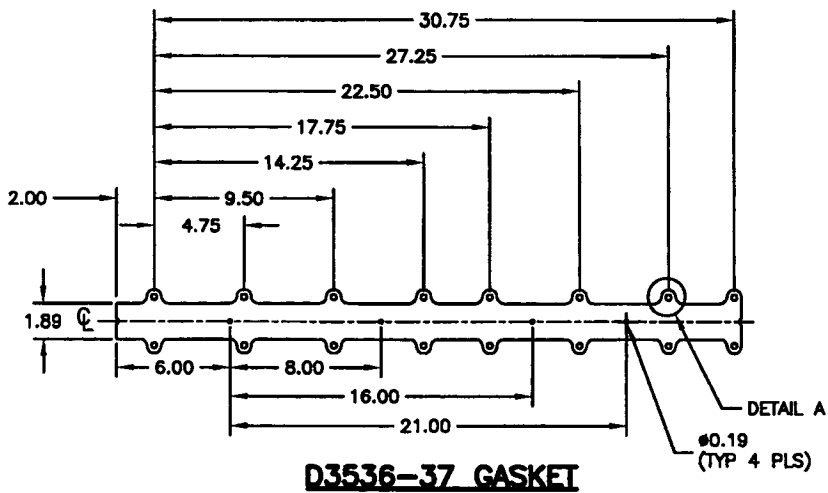
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NO. 51992

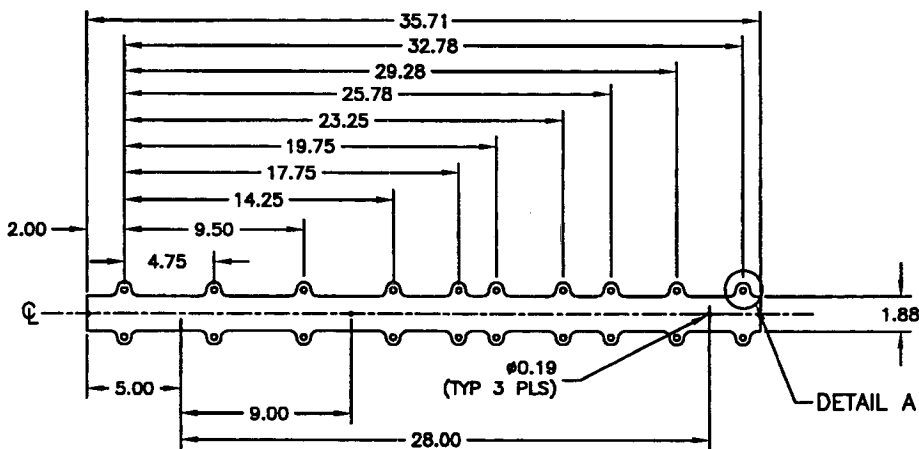
**DART**

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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 5 OF 6	
		SCALE <b>1:10</b>	

07.02.12  
07.02.12  
07.02.12



**D3536-37 GASKET**



**D3536-39 GASKET**

**NOTES**

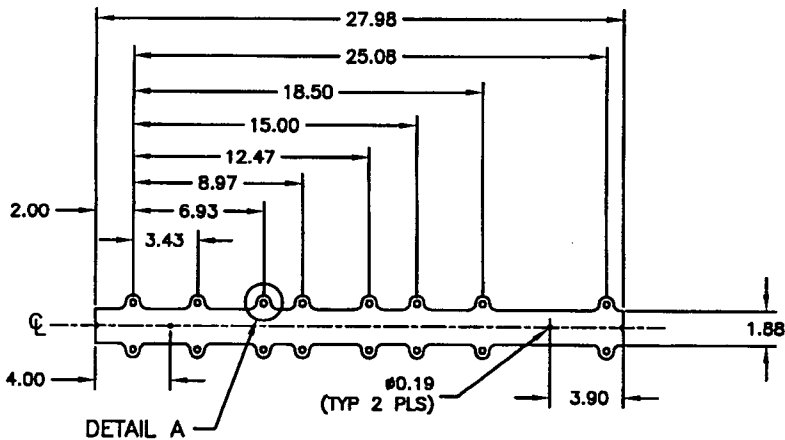
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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WORK ORDER  
NO. 31996

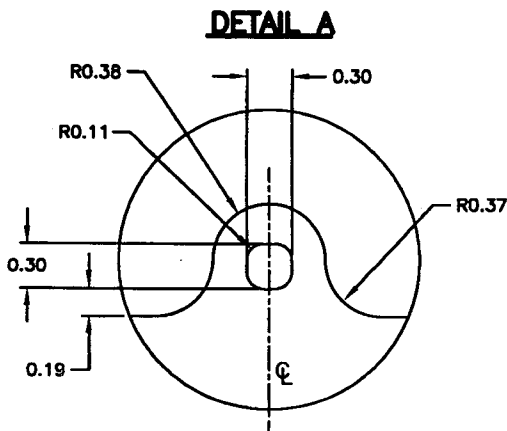
# DART

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 6 OF 6
	SCALE <b>1:10</b>	

REMOVED  
07.02.12 *[Signature]*



## D3536-41 GASKET



### NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Ø
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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